

Date: Tuesday, 3/4/2008 11:29:46 AM  
 User: Chantal Lavoie

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : ANGLE EXTRUSION
<b>Job Number</b> : 37670	
<b>Estimate Number</b> : 10050	
<b>P.O. Number</b> :	<b>Part Number</b> : D6207
<b>This Issue</b> : 3/4/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D6207 REV A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 35960	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 3/11/2008 <b>Qty:</b> 20 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :	
<b>Comment</b> : Est. A: 02.03.15      New Issue NG	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	PG	PURCHASING
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5922



Comment: PURCHASING

Issue P/O: ~~5886~~

C 208103117

(20ft)

a) Description: Angle extrusion 25 ft long 1.000" x 1.000" x 0.125"

b) Material: 6061-T6/T6511 (QQ-A-200/8)

c) Minimum ultimate tensile strength = 38 ksi

d) Minimum yield tensile strength = 35 ksi

2.0	D6207P	Angle Extrusion 1x1x.125
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Comment: Qty.: 1.0000 f(s)/Unit      Total: 20.0000 f(s)

Angle Extrusion 1x1x.125

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive &amp; Inspect For Transit Damage

Ensure material certification is attached

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Ensure Material certification comply to Dwg D6207

Check hardness with Webster tester

U 08.03.24  
 08.03.24

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *Machining*

*08.03.25*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes (No) DQA: PD Date: 08/03/25  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/4/2008 11:29:46 AM  
User: Chantal Lavoie

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ANGLE EXTRUSION

Job Number: 37670

Part Number: D6207

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(22)

Comment: FINAL INSPECTION/W/O RELEASE

AP-08103/05

Job Completion



W 08-03-25

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

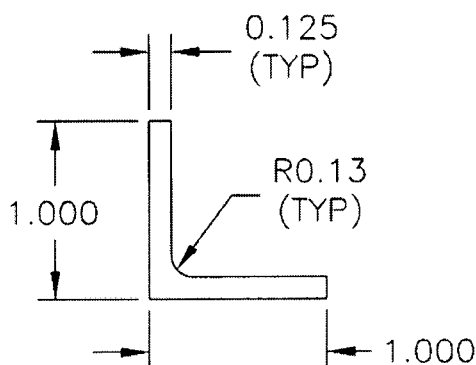
NOTE: Date & initial all entries



DESIGN #	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D6207	REV. A SHEET 1 OF 1
DATE 02.03.13		TITLE ANGLE EXTRUSION	SCALE 1:1
A	02.03.13	NEW ISSUE	

RELEASED  
02.03.13

## SPECIFICATION CONTROL DRAWING



D6207-XXX ANGLE EXTRUSION  
WHERE XXX IS LENGTH IN INCHES

EG.  
D6207-027 IS 27 INCHES LONG

PURCHASE MATERIAL: ALUMINUM ANGLE  
1.000" x 1.000" x 0.125"  
6061-T6/T6511 (QQ-A-200/8)  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi  
MINIMUM YIELD TENSILE STRENGTH = 35 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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CL08/03/04

W/O: 37670

# Aluminium Mill Certificate

Carl. No.: KAP604321

Customer:

Contract No.: CA-SM41597

Alloy Temper: 6061-T6511

Container No.: OOLU 727179W40

Standards: ASTM-B221

Shipment Date: Jul 23 2004

PO No: 363153

Invoice No: M43537

			6061 Chemical Composition (%)												Tensile Strength		Yield		Elongation	
Product Code	Dis No	Specification	Heat No.	Si	Mg	Fe	Cu	Mn	Zn	Cr	Ti	Pb	Bi	Zr	Al	N/mm <sup>2</sup>	ksi	N/mm <sup>2</sup>	ksi	%
			0.40-0.80	0.80-1.20	0.70 max.	0.15-0.40	0.15 max.	0.20 max.	0.04-0.15	0.15 max.	--	--	--	Rem.	265	38	246	36	8	
6308-1025	6079	ANGLE 54X34X1/8RF	4D093	0.656	1.028	0.129	0.228	0.010	0.008	0.145	0.008				Rem.	302	44.0	268	39.0	13.5
6308-1075	6009-318	ANGLE 1X1X1/8RF	4D093	0.656	1.028	0.129	0.228	0.010	0.008	0.145	0.008				Rem.	327	47.0	276	40.0	12.1

Kam Kiu Aluminium Group hereby certifies that metal shipped under the above mentioned PO No, Contract No, and Container No has been inspected and tested, and found in conformance with the applicable specifications forming a part of the description set forth in Kam Kiu's Sales Contract.

Prepared By:

Waley

Checked By:



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RYERS

4/8/2005 5:38 PAGE 001/004 Fax Server